

Date: Monday, 11/08/2008 10:20:21 AM
 User: Linda Lacelle

Process Sheet

SPLIT-2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 41082		
Estimate Number	: 12712		
P.O. Number	:	Part Number	: D35371
This Issue	: 11/08/2008 S.O. No. :	Drawing Number	: D3537 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11/08/2008 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 38941	Material	:
Written By	:	Due Date	: 25/08/2008
Checked & Approved By	: <u>JLO 08.8.11</u>	Qty:	100 Um: Each
Comment	: Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.1113 sf(s)/Unit Total: 11.1300 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 108724 1B 8-8-14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: CProg Rev: C1B 8-8-14

(105)

2-Deburr if necessary

1B 8-8-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 8-8-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

108-08-18105 cancelled.

5.0	BRAKE NC	NC BRAKE
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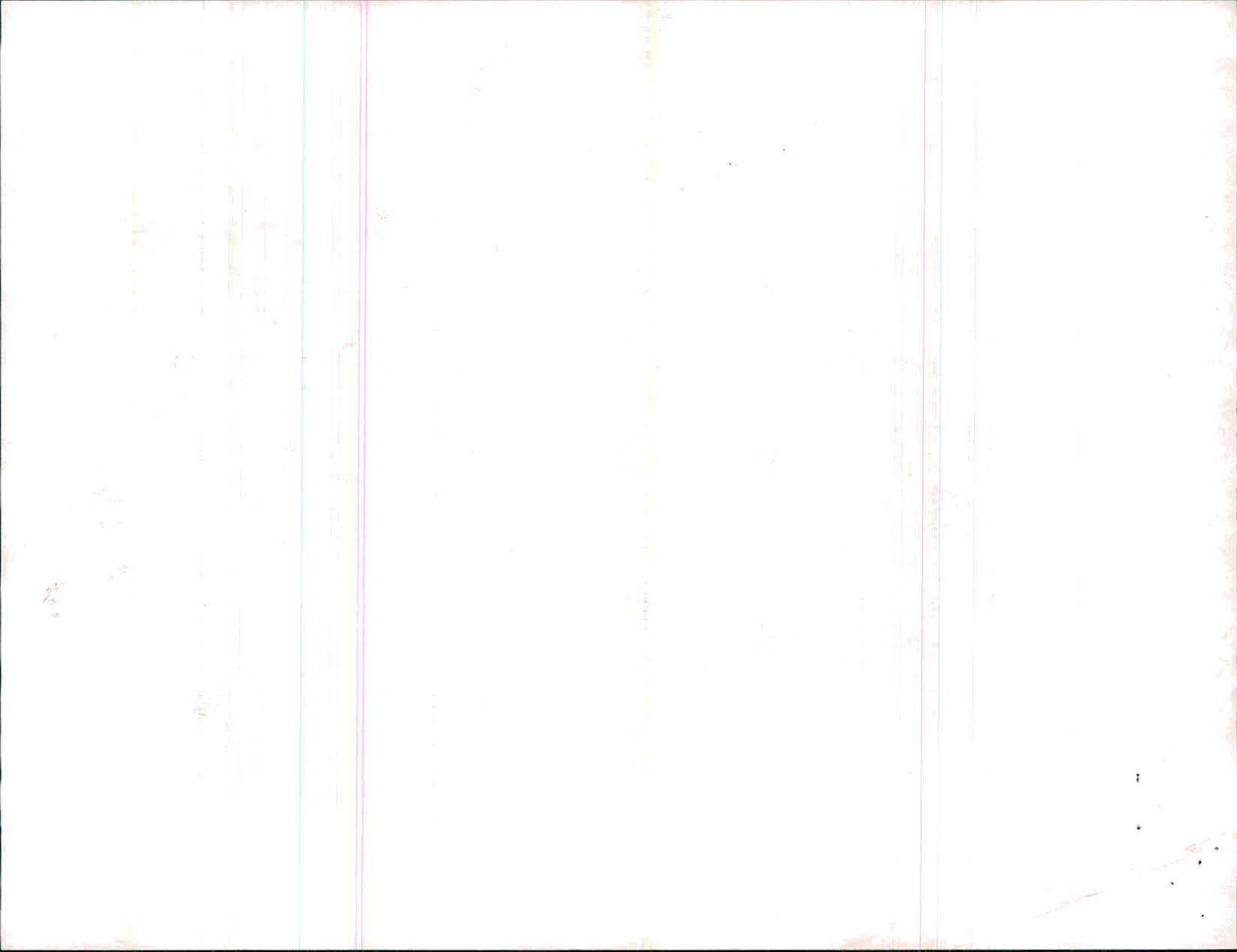


Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

SP 08/08/19 (105)



Date: Monday, 11/08/2008 10:20:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 41082

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

~~2~~ M108631, 108709, M109303

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

✓27

EL 8-10-16

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S

08/10/20

(x27)

PD →

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/10/20

(x27)

counter

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:45
320°F
1:15

m-f

08/10/20

(27X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ

08/10/20

(27)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-17

FZ

08/10/20

(27)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



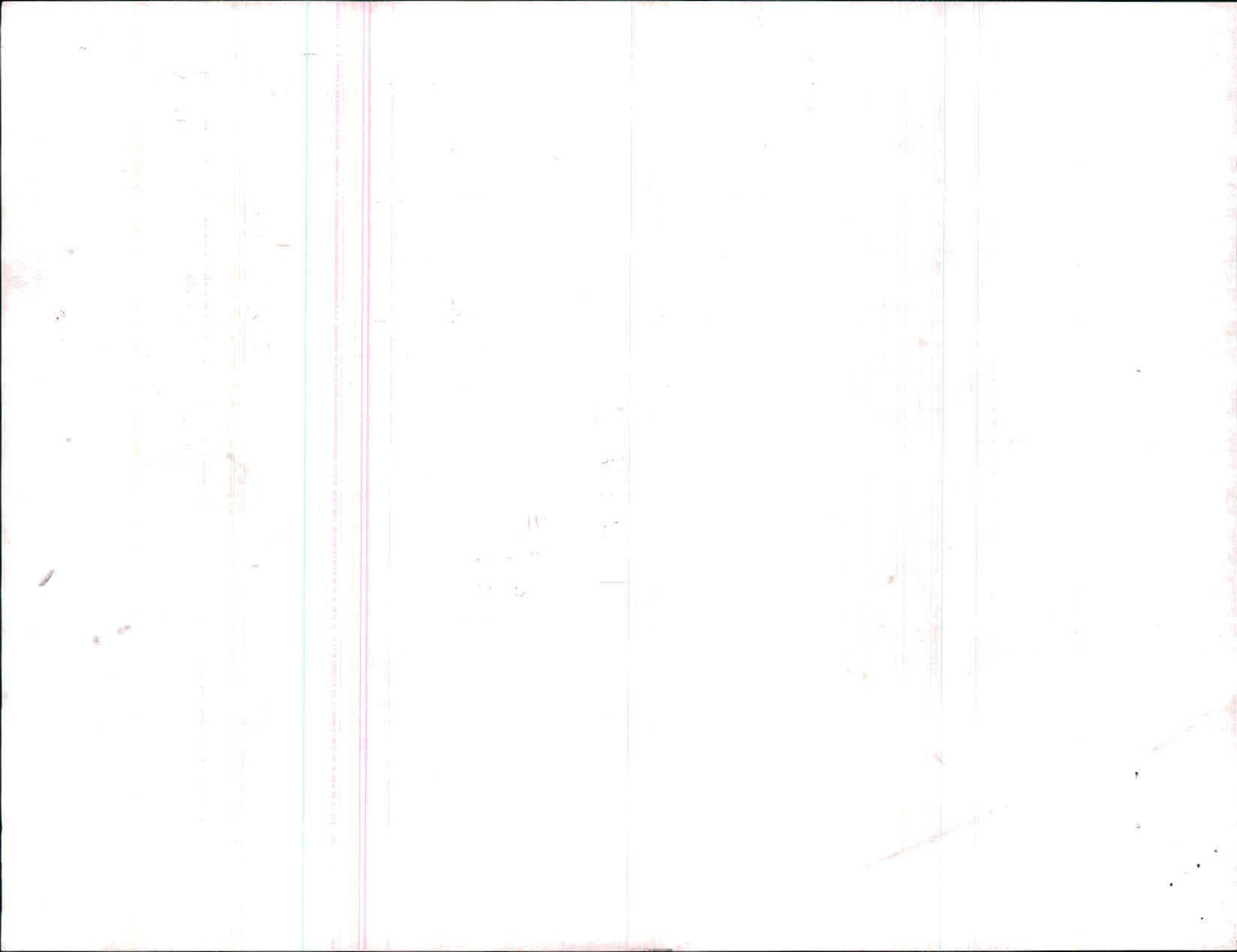
Comment: FINAL INSPECTION/W/O RELEASE

08/10/21

Job Completion




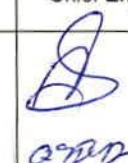




MF 08-10-20



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3537-1 PAR #: N/A Fault Category: Prod/Fab Log NCR: Yes No DQA: D Date: 08/10/22
 Resolution: _____ Disposition: _____ QA: N/C Closed: KJ Date: 08/10/22

NCR: <u>41082</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/10/17	60	During welding inspection it was found on Qty (X) that the end of the wearplate was melted through.		Build out Marking too make it less noticeable	 8-10-20	 08/10/20	 08/10/20	 8/10/17
		R.C. welder didn't notice that he was that close to the end while he was hand facing Lack of Attention.						 8/10/17

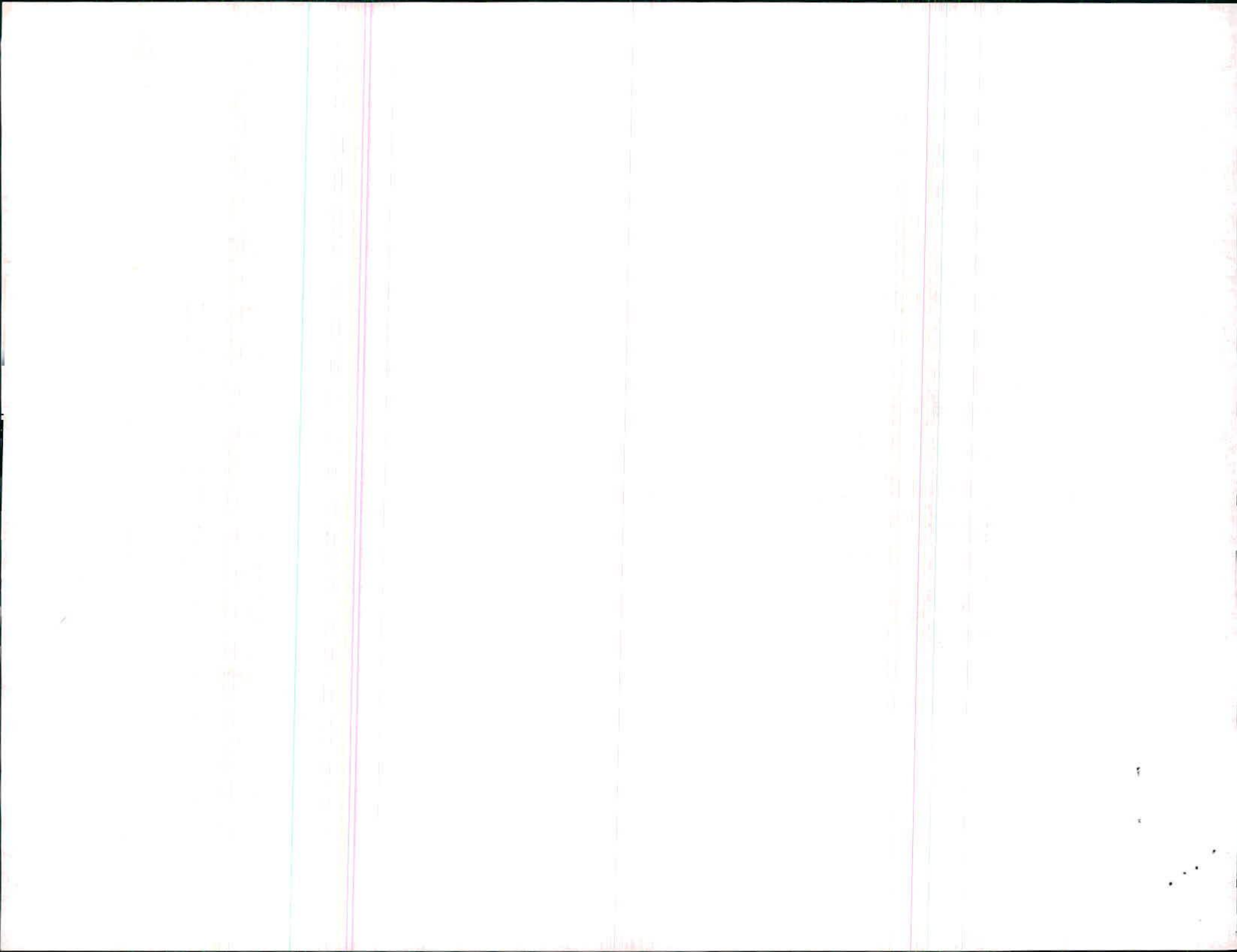
NOTE: Date & initial all entries

पुस्तक संख्या: 12345

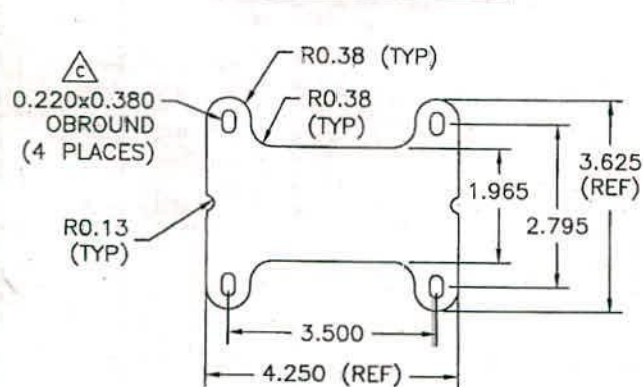
4/14

4/27/2020, 12:27

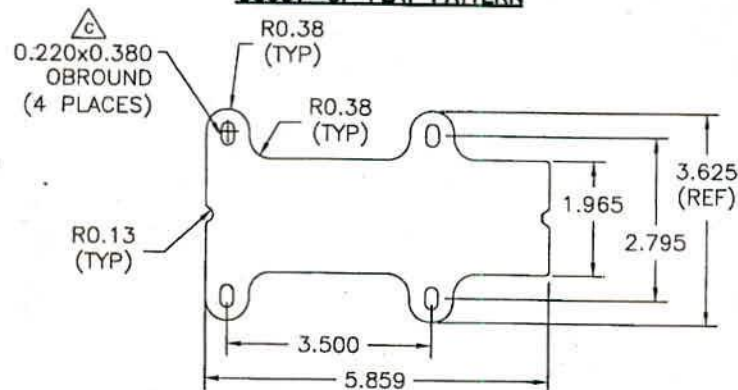
[illegible]



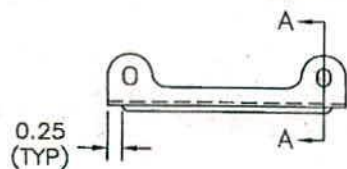
D3537-1F FLAT PATTERN



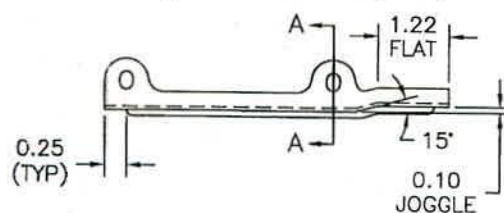
D3537-3F FLAT PATTERN



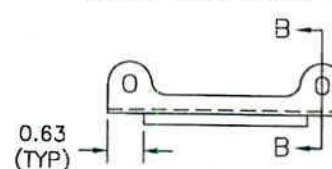
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



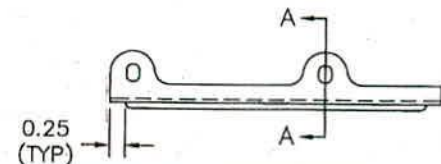
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



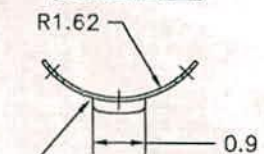
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

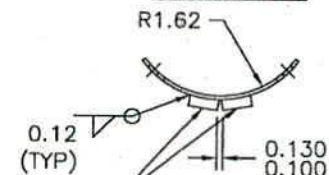


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07-05-08 AM
DART ECU
962

D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	A	APPROVED A
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE
		1:2

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